



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D119-796-035
Job Sheet 180170



Part No: D119-796-035

Job Qty: 1 ea

Part Name: AW119 Landing Gear Assembly - Heavy-Duty, Run-on Landing Wearplates, Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 8/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-035 REV B, IIN-D119-796 REV F IPP REV:A NEW ISSUE 15-05-13 JLM VERIFIED BY:DD
IPP REV:B 15.08.25 AS PER ECN15-580 DD VERF:JLM IPP REV:C 18.03.22 ADDED D5449-1 DD
VERF:JFS

Ship Via:

SOS

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	8/22/18	8/22/18	0.00	0.00	Start Up Stores/Pkg-1	189	AUG 21 2018
100	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging1-1	189	AUG 21 2018
110	HandFinish	1 pcs	8/22/18	8/22/18	0.00	0.00	HandFinish4	189	38
120	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC5	189	9-89
125	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging1-1	189	38
127	QC	1 pcs	8/22/18	8/22/18	0.00	0.00	QC4	189	38
130	Packaging	1 pcs	8/22/18	8/22/18	0.00	0.00	Packaging3-1	189	38
140	QC21-FG	1 Ea	8/22/18	8/22/18	0.00	0.00	QC21	189	21 AUG 22 2018

Part Op 100 - Photocopy bluefile and create labels as per PPP D119-796-035 chg 004/ D119-646-243 paperwork
Descriptions: 110 - ASSEMBLE AS PER DWG AND NOTES 8,9,10,11 ASSEMBLE WITH PROSEAL BATCH: 38848-2-INSTALL
DECAL D2729-4
130 - Identify and pack for shipping as per PPP D119-796-035 Location: _____ PPP Rev: _____

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	8 Ea (8 ea)	90-Start up Operation	5027836
AN3C50A	Bolt	16 Ea (16 ea)	90-Start up Operation	5079135
AN4C6A	Bolt	24 Ea (24 ea)	90-Start up Operation	5077515
D119-646-243	AW119 Repl. Skidtube with Heavy Duty Wearplates, Float Compatible -Fits LH or RH	2 Ea (2 ea)	90-Start up Operation	5089667 14 5089683 K
D119-796-151	Fwd Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5103888
D119-796-251	Aft Crosstube Installation With Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	5077467 5079000
D2652	Bushing	48 Ea (48 ea)	90-Start up Operation	5054607 5077682
D3407-041	Tow Ring	2 Ea (2 ea)	90-Start up Operation	5100215
D3417-5	Washer	4 Ea (4 ea)	90-Start up Operation	50898883 50898883
D3456-1	Washer	2 Ea (2 ea)	90-Start up Operation	5079335

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition
Completed By _____ Ind / Supervisor _____ val Verification _____ QA Coordinator Approval _____	

DART AEROSPACE
 Container No: S103832
 Part: D119 - 796 - 035
 Job No: 180170
 Serial No/Batch: S103832
 Revision: B / F
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH14 - 45 - Issue 1, GMA/STC SR03504NY 15/01/28, EASA

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 CANADA
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Root Cause		FAULT CATEGORY	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐	OTHER : _____	

D3672-3	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	<u>5027022</u>
D3672-7	Washer, Phenolic	48 Ea (48 ea)	90-Start up Operation	<u>5027022</u>
D3883-1	Saddle, Outboard LH	2 Ea (2 ea)	90-Start up Operation	<u>5015442</u>
D3883-2	Saddle, Outside RH	2 Ea (2 ea)	90-Start up Operation	<u>5081017X1</u> <u>5102025</u>
D3884-1	Saddle, Inside LH	2 Ea (2 ea)	90-Start up Operation	<u>5081399X1</u> <u>5102810</u>
D3884-2	Saddle, Inside RH	2 Ea (2 ea)	90-Start up Operation	<u>507480</u>
D3886-041	Lug Assembly	4 Ea (4 ea)	90-Start up Operation	<u>5080306</u>
MS21043-3	Nut	24 Ea (24 ea)	90-Start up Operation	<u>5072757</u>
MS21043-4	Nut	26 Ea (26 ea)	90-Start up Operation	<u>5062620</u>
MS21043-5	Nut	8 Ea (8 ea)	90-Start up Operation	<u>5089277</u>
MS21250-05048	Bolt (Use Ms21250-05-048)	8 Ea (8 ea)	90-Start up Operation	<u>5024470</u>
NAS1149C0332R	Washer	24 Ea (24 ea)	90-Start up Operation	<u>5076013</u>
NAS1149C0432R	Washer	48 Ea (48 ea)	90-Start up Operation	<u>504987</u>
NAS1149C0532R	Washer	16 Ea (16 ea)	90-Start up Operation	<u>5050052</u>
D5449-1	Float Saddle Washer	4 Ea (4 ea)	90-Start up Operation	<u>5055957</u>
MS21920-28	Clamp	2 Ea (2 ea)	125-Packaging	<u>5100711X1</u> <u>3X</u> <u>5163308</u> <u>5093575</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C46A	8	122	0
	AN3C50A	16	159	0
	AN4C6A	24	317	0
	D119-646-243	2	0	0
	D119-796-151	1	1	0
	D119-796-251	1	0	0
	D2652	48	389	0
	D3407-041	2	18	0
	D3417-5	4	19	0
	D3456-1	2	306	0
	D3672-3	48	1,099	0
	D3672-7	48	561	0
	D3883-1	2	5	0
	D3883-2	2	5	0
	D3884-1	2	11	0
	D3884-2	2	14	0
	D3886-041	4	20	0
	D5449-1	4	1	0
	MS21043-3	24	1,125	0
	MS21043-4	26	401	0
	MS21043-5	8	166	0
	MS21250-05048	8	36	0
	NAS1149C0332R	24	5,075	0
	NAS1149C0432R	48	1,715	0
	NAS1149C0532R	16	217	0
125-Packaging	MS21920-28	2	41	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																				
Large Fab ☐	Composite ☐	Supplier ☐																						

Date : _____ Step #: _____ QTY Effective : _____ MRB (QSI042) Approval _____

Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause				FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____							



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RBE703A94-1130-01
Job Sheet 180186



Part No: RBE703A94-1130-01

Job Qty: 5 ea

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 8/6/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	8/6/18	8/6/18	0.00	0.00	Start Up Small Fab-2		MU
110	Small Fab	5 pcs	8/6/18	8/6/18	0.00	5.00	Small Fab-3		MU DAS
120	QC	5 pcs	8/6/18	8/6/18	0.00	0.00	QC5		38
130	Packaging	5 pcs	8/6/18	8/6/18	0.00	0.00	Packaging3-1		MU 9-89
140	QC21-FG	5 Ea	8/6/18	8/6/18	0.00	0.00	QC21		DAS AUG 24 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	20 Ea (4 ea)	90-Start up Operation	
APP-1450-E	Case	5 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	5 Ea (1 ea)	90-Start up Operation	
RBE703A94-1130-01-01	Immobilizing Clip Assembly	5 Ea (1 ea)	90-Start up Operation	3103590
RBE703A94-1130-01-23	Deflection Clip Assembly	5 Ea (1 ea)	90-Start up Operation	3103518
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	5 pcs (1 ea)	90-Start up Operation	
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	5 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	20	263	0
	APP-1450-E	5	1	0
	RB41011	5	847	0
	RBE703A94-1130-01-01	5	0	0
	RBE703A94-1130-01-23	5	0	0
	RBE703A94-1130-01-47	5	0	0
	RBE703A94-1130-01-49	5	0	0

Part Specifications

Specifications could not be found.

Plex 6/29/18 3:33 PM dart.logan.david



Container No: S104721



Part: RBE703A94-1130-01

Job No: 180186

Serial No/Batch: S104721

Revision: K

Inspector:

Exp Date:

Instructions:

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Date: 08/23/18

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